

Work Order ID 70414

Tuesday, June 07, 2011 1:39:46 PM



Page 1

Item ID: D4038-3

Accept



Setup Start



Revision ID:

Item Name: Angle, Aft, LH

Stop



Start Date: 6/7/2011 Start Qty: 10.00



Cust Item ID:

Required Date: 6/21/2011 Req'd Qty: 10.00



Customer:

Reference:

Approvals: Process Plan: CZ Date: 11/06/07 Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start



Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
D4038	E

100

0.00

11/06/09

10



Bandsaw

Memo

0.00

Jeaspa Bandsaw

Cut Blank 7.625" long

10

0.00



HAAS 1

Deutch

Memo

0.00

HAAS CNC vertical machine #1

Mills as per Dwg & Folio FA880

Dwg Rev: _____

Folio Rev: _____

Deburr

issue P10: 14260

CZ 11/06/09 10

Dan's Precision machine as per dwg D 4038

REV. E

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Page 2

Item ID: D4038-3

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Item Name: Angle, Aft, LH

Start Date: 6/7/2011 Start Qty: 10.00



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Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start



Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp120 *QC*QC
Quality Control*QC* Inspect parts off machine FAI/FAIB

0.00

Memo

0.00

*rec'd + inspect for transit damage
attached c/c to W/O*

130

QC
Quality Control*QC* Inspect parts - second check

0.00

Memo

0.00

8 11/07/05*P4/7/05 (9)**Pto →*

140

HandFinish
Hand Finishing

Chemical Conversion Coat per QSI005 4.1

0.00

Memo

0.00

x9 11/07/03

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

*see Pink NCR
11-712*

Part No: D4080-3 PAR #: _____ Fault Category: ~~St~~ Squelcher NCR: (Yes) No DQA: _____ Date: _____

Resolution: Scrap Disposition: Scrap QA: N/C Closed: _____ Date: _____

NCR: <u>70414</u>		WORK ORDER NON-CONFORMANCE (NCR) # <u>31.97</u>						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
<u>11/7/15</u>	<u>#120</u>	<u>Qty +1 Part Scraped by the squelcher R.C.</u>	<u>CP</u> <u>11.07.06</u> <u>PS/642</u>	<u>Scrap + Destroy no Replace</u>	<u>[Signature]</u> <u>11/07/11</u>	<u>[Signature]</u>	<u>CP</u> <u>11.07.06</u> <u>PS/642</u>	<u>[Signature]</u> <u>11/07/15</u>
				<u>Scraped - first part = Scrap e-mail attached P.T.O</u>	<u>CP</u> <u>11/07/11</u>	<u>[Signature]</u>		<u>[Signature]</u> <u>11/07/15</u>

NOTE: Date & initial all entries

Work Order ID 70414

Tuesday, June 07, 2011 1:39:46 PM



Page 3

Item ID: D4038-3

Accept



Setup Start



Revision ID:

Stop



Item Name: Angle, Aft, LH

Start Date: 6/7/2011 Start Qty: 10.00



Cust Item ID:

Required Date: 6/21/2011 Req'd Qty: 10.00



Customer:

Reference:

Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

150

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

Quality Control

9x 0 M- 11/07/05

160

Identify as per dwg & Stock Location: 114

0.00



Packaging

Memo

0.00

Packaging

11/7/05 8/90

170

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

*11/7/05**CME**11-07-06*

W/O:		WORK ORDER CHANGES					
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NOTE: Date & initial all entries

Picklist Print

Tuesday, June 07, 2011 1:39:43 PM

Page 1

Work Order ID: 70414



Parent Item: D4038-3



Parent Item Name: Angle, Aft, LH

Start Date: 6/7/2011

Required Date: 6/21/2011

Start Qty: 10.00

Required Qty: 10.00

Comments: Ipp Rev:A New Issue 09-12-15 JLM Verified By:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6A4.000W.250		Purchased	No			100	f	15.5745	0.7	7.368421			

6061T6 ANGLE 4.00 x 4.00 x .250

Location	Loc Qty	Loc Code
MAT006	14.29	
117285	14.29	
MAT007	1.2845	
114507	1.2845	

2.4 f 11/06/09

D4038-3P

PC 4/2/5 (9)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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NOTE: Date & initial all entries

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NOTE: Date & initial all entries

DAN'S PRECISION TOOLS INC.

2560 Devine Road, Vars, ON K0A3H0
Tel: (613) 835-3097 Fax: (613) 835-3760
support@dans-precision-tools.com

RE: CERTIFICATE OF COMPLIANCE

To: DART AEROSPACE LTD.

1270 Aberdeen Street
Hawkesbury ON K6A-1K7

Tel: (613) 632-5200

Fax: (613) 632-5246

- We Certify that the part listed below meets the intent of the Purchase Order, and all applicable drawings and specifications.

Date : 04-Jul-11

Purchase Order : PO14260

Packing Slip : 10537

Part Number : D4038-3revE

Quantity : 9

S 11/07/05

Per: _____

SJ
For Dan's Precision Tools Inc.

Chantal Lavoie

From: Linda Lacelle <llacelle@dartaero.com>
Sent: June 28, 2011 7:23 AM
To: 'Khaled - Dan's Precision Tools'; 'JEANLUC MENARD'
Cc: 'Chantal Lavoie'
Subject: RE: PO14260

Hi again Khaled,
I just checked the cost of the blank, it's not worth enough to deduct the cost for the scrap piece, so forget about it...
Thanks for your fast delievry!

Linda

From: Khaled - Dan's Precision Tools [mailto:khaled@dans-precision-tools.com]
Sent: June 27, 2011 3:15 PM
To: Linda Lacelle; JEANLUC MENARD
Cc: 'Chantal Lavoie'
Subject: Re: PO14260

Good afternoon,

Thank you for the updated PO. Everything is correct.

I must admit though that I'm not sure I understand your question. But if it is about subtracting material cost of scrapped piece of D4078-1 from price, you certainly can. If not please advise.

Thank you,
Khaled

----- Original Message -----

From: Linda Lacelle
To: JEANLUC MENARD ; khaled@dans-precision-tools.com
Cc: 'Chantal Lavoie'
Sent: Monday, June 27, 2011 12:53 PM
Subject: RE: PO14260

Hi all,
Line 1,2 & 3 can be short shipped, no problem. Attached is the revised PO, let me know if we got it right. As for the 1 blank scrap, can we remove it from the price of the item?
Thx
Linda Lacelle
Production Manager
Dart Aerospace

From: Jean-Luc Menard [mailto:jmenard@dartaero.com]
Sent: June 27, 2011 12:44 PM
To: L Lacelle
Subject: FW: PO14260

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries

From: Khaled - Dan's Precision Tools [mailto:khaled@dans-precision-tools.com]

Sent: June 27, 2011 12:17 PM

To: DART - Jean-Luc Menard

Subject: PO14260

Bonjour Jean-Luc,

We'll have 14 to 15 lines on this PO delivered this afternoon. Driver will be leaving here around 1:30.

I have, however, a couple of issues I'd like to bring to your attention:

1. D4038-11: One blank was cut short, but we ran 10 pieces accidentally using a D4038-9 blank. Result = we're short 1 piece of D4038-9.
2. D4038-7: Short 1 piece. We ran it as D4038-6.
3. D4078-1: Short 1 piece. We scrapped it during production.
4. You have supplied and we ran 11 pieces of 3573-1 and 3573-8. PO calls for 10 of each. If 11 is what you require please amend PO to match. If not I will send them to you as spares.

Could you please advise as to whether we could ship short for 1,2 and 3 above or if you'd like us to pick up replacement material for more parts?

Give a call when you have a moment. I need to talk to you regarding specs for Rack and Pinion as well

Thank you,
Khaled

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Linda Lacelle

From: Jean-Luc Menard <jmenard@dartaero.com>
Sent: July 5, 2011 7:54 AM
To: L Lacelle
Subject: FW: PO14260 & PO14324

From: Khaled - Dan's Precision Tools [mailto:khaled@dans-precision-tools.com]
Sent: July 4, 2011 4:11 PM
To: DART - Jean-Luc Menard
Subject: PO14260 & PO14324

Bonjour Jean-Luc,

We have shipped the balance of PO14260 as well as Line 1 of PO14324 (Lug). We have discrepancies in quantity between what was ordered and we have shipped regarding the following items:

D4038-1: Material Short. Shipped 2 of 3
D4038-3: Scrapped 1 pce. Shipped 9 of 10
D3414-3: Lost 2 pcs during production. Shipped 38 of 40

D3404-1 on PO14324: Shipped 37 of 40 (Lost 3 pcs)

Could you please advice on how to proceed?

Thank you,
Khaled